

Work Order ID 57956

April 21, 2010 8:45:01 AM



Page 1

Item ID: D3929-042

Accept



Setup Start



Revision ID:

Item Name: Gusset Assembly

Stop



Start Date: 21/04/2010 Start Qty: 6.00



Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan: *PL*Date: 10-4-21 Tooling: _____ Date: _____

Run Start



QC: _____

Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr	Revision Nbr
D3929	A

100



Waterjet

FLOW CNC Waterjet

Memo

1-Cut as per Dwg D3929
Dwg Rev: A
Prog Rev: A

0.00

0.00

FB 10-4-26

(6)

2-Deburr if necessary

110



QC

Quality Control

QC2- Inspect parts off machine FAI/FAIB

0.00

Memo

0.00

FB 10-4-26

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

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Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

120



QC

Quality Control

Operation
Description

QC8- Inspect parts - second check

Set Up/
Run Hours

0.00

Sw/04/20

Draw
Number

0.00

Draw
Rev.

0.00

Plan
Code

0.00

Accept
Qty

0.00

Reject
Qty

0.00

Reject
Number

0.00

Reject
Stamp

0.00

130

Packaging
Packaging

Pick Kit

Memo

0.00

0.00

N/A

140

Large Fab
Large Fab

Memo

0.00

Weld bushings D3907-1 as per dwg D3929

316L rod batch: 111679

GPL 04/28

W/O:		WORK ORDER CHANGES					
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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150



QC9- Inspect visual per QSI004- Fusion Welds

0.00

0.00

(6) PD 10-04-29

QC

Quality Control

160



QC5- Inspect part completeness to step on W/O

0.00

Sudonbag

0.00

(6)

-042

QC

Quality Control

170



Identify as per dwg & Stock Location: WA

0.00

SAY

0.00

10-04-29

6

Packaging

Packaging

W/O:		WORK ORDER CHANGES					
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Stop



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Cust Item ID:

Required Date: 28/04/2010 Req'd Qty: 6.00



Customer:

Reference:

Approvals: Process Plan:

Date: _____

Tooling: _____

Date: _____

Run Start



QC:

Date: _____

SPC (Y/N):

Date: _____

Stop

Sequence ID/
Work Center ID

180

Operation
Description

QC21- Final Inspection - Work Order Release

Set Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

QC

Memo

0.00

Quality Control

10/04/30
MF

10-4-30

W/O:		WORK ORDER CHANGES					
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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NOTE: Date & initial all entries

Picklist Print

April 21, 2010 8:45:05 AM

Page 1

Work Order ID: 57956



Parent Item: D3929-042



Parent Item Name: Gusset Assembly

Start Date: 21/04/2010

Required Date: 28/04/2010

Comments:

Start Qty: 6.00

Required Qty: 6.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
M304S11GA		Purchased		No		100	sf	14.2200	2.8421			

304/316 0.125 Sheet



RB 10-4-26

(b)

D3907-1



Bushing

Manufactured

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
MAT19	14.22	

112663

14.22

130 Each 31.0000 12.0000

112663

LPC 10-04-28

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		

WA
57242

31

31

12

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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NOTE:-Date & initial all entries

DART AEROSPACE LTD	Work Order:	57954
Description: Support Gusset	Part Number:	D3929-1
Inspection Dwg: D3929	Rev: A	Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

X First Article Prototype

Measured by: <u>HB</u>	Audited by: <u>S</u>	Prototype Approval:	N/A
Date: <u>10-4-20</u>	Date: <u>10/04/20</u>		Date: N/A

Rev	Date	Change	Revised by	Approved
A	09.05.27	New Issue	P/O D3929-041/-042	KJ

W/O:		WORK ORDER CHANGES					
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NOTE: Date & initial all entries

8

7

6

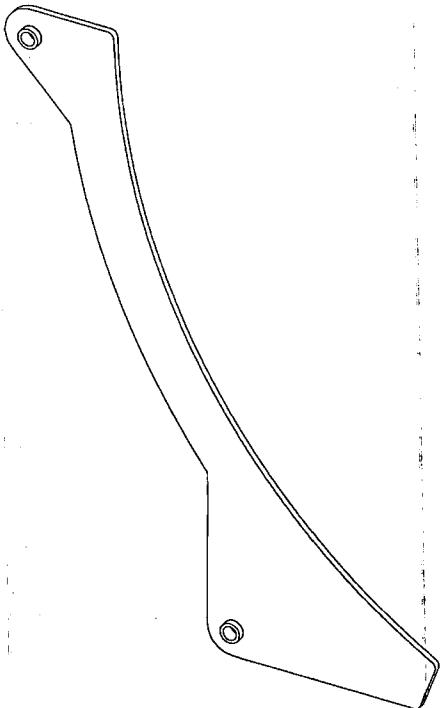
5

4

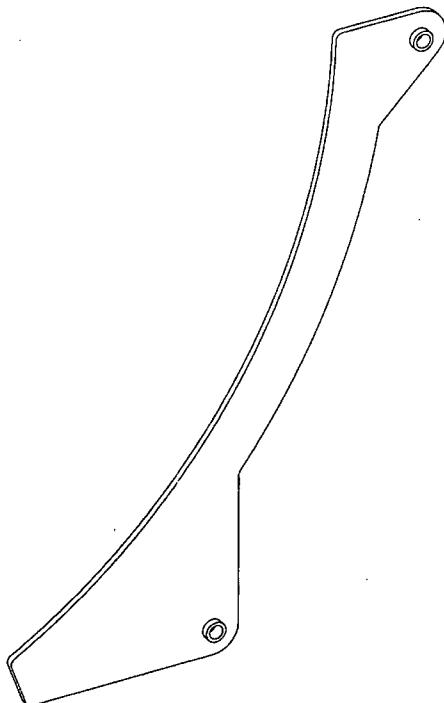
3

2

1



D3929-041 GUSSET ASSEMBLY



D3929-042 GUSSET ASSEMBLY

ITEM	QTY -041	QTY -042	P/N	DESCRIPTION
1	X		D3929-041	GUSSET ASSEMBLY
2		X	D3929-042	GUSSET ASSEMBLY
11	2	2	D3907-1	BUSHING
12	1	1	D3929-1	SUPPORT GUSSET

SHOP COPY
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UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDPR

NO. 57954*By 10-4-21*

RELEASED
8/10/21 M

A	NEW ISSUE	MB	09.04.03
REV.	DESCRIPTION	BY	DATE
DESIGN	<i>1</i>		
DRAWN	<i>1</i>		
CHECKED	<i>PMA</i>	REV. A	
MFG. APPR.	<i>1</i>	DRAWING NO.	
APPROVED	<i>1</i>	D3929	SHEET 1 OF 3
DE APPR.	<i>1</i>	TITLE	SCALE
DATE	09.04.03	GUSSET ASSEMBLY	NTS

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A
NOTES:
1) MATERIAL: N/A
2) FINISH: N/A
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3929-04X" USING FINE POINT PERMANENT INK MARKER
7) WEIGHT: 0.73 lbs EACH
8) WELDING: PER DART QSI 004

8

7

6

5

4

3

2

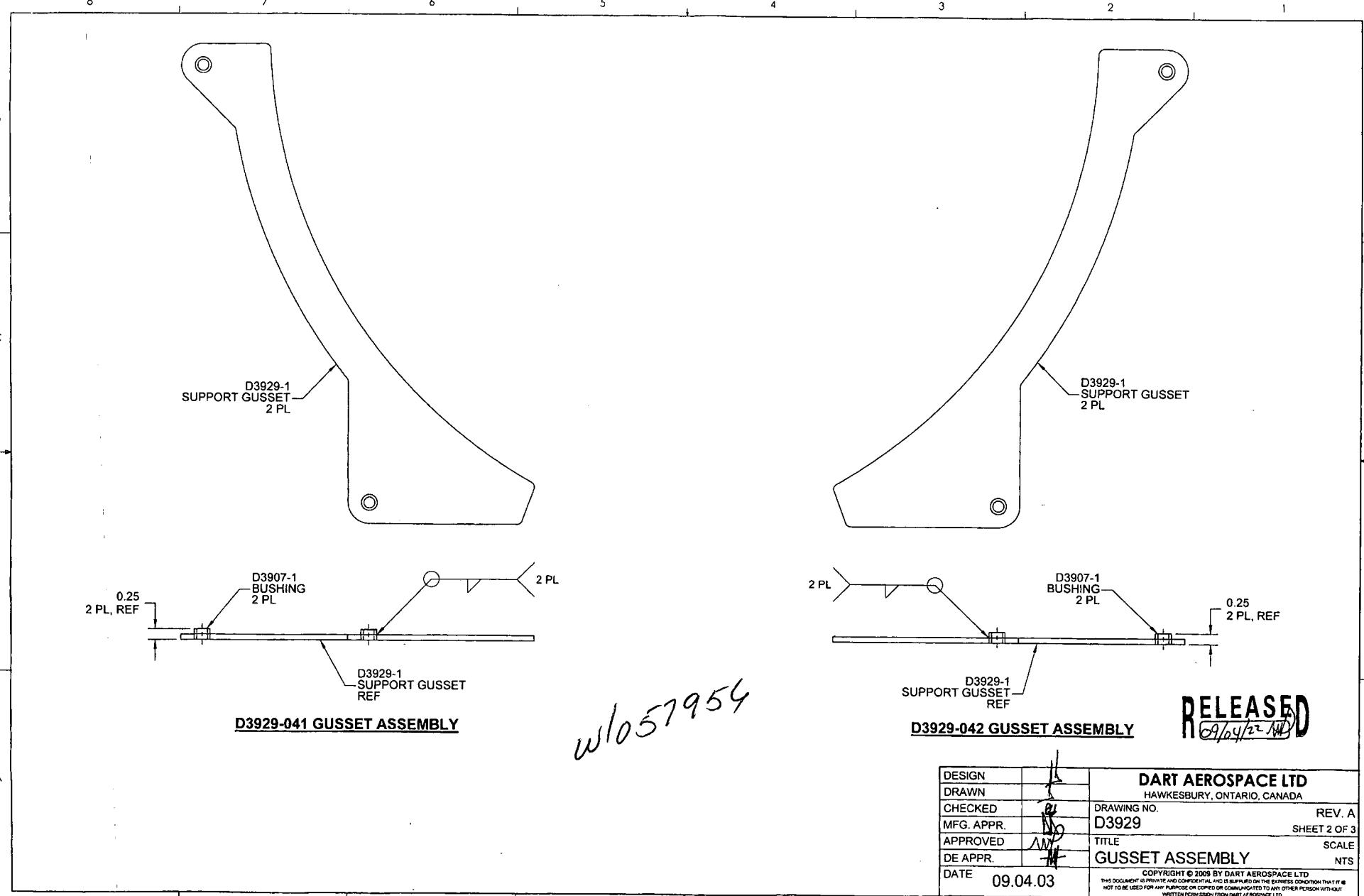
1

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DESIGN	<i>15</i>	DART AEROSPACE LTD		
DRAWN	<i>15</i>	HAWKESBURY, ONTARIO, CANADA		
CHECKED	<i>15</i>	DRAWING NO. D3929		
MFG. APPR.	<i>15</i>	REV. A		
APPROVED	<i>15</i>	SHEET 2 OF 3		
DE APPR.	<i>15</i>	TITLE GUSSET ASSEMBLY		
DATE	09.04.03	SCALE NTS		

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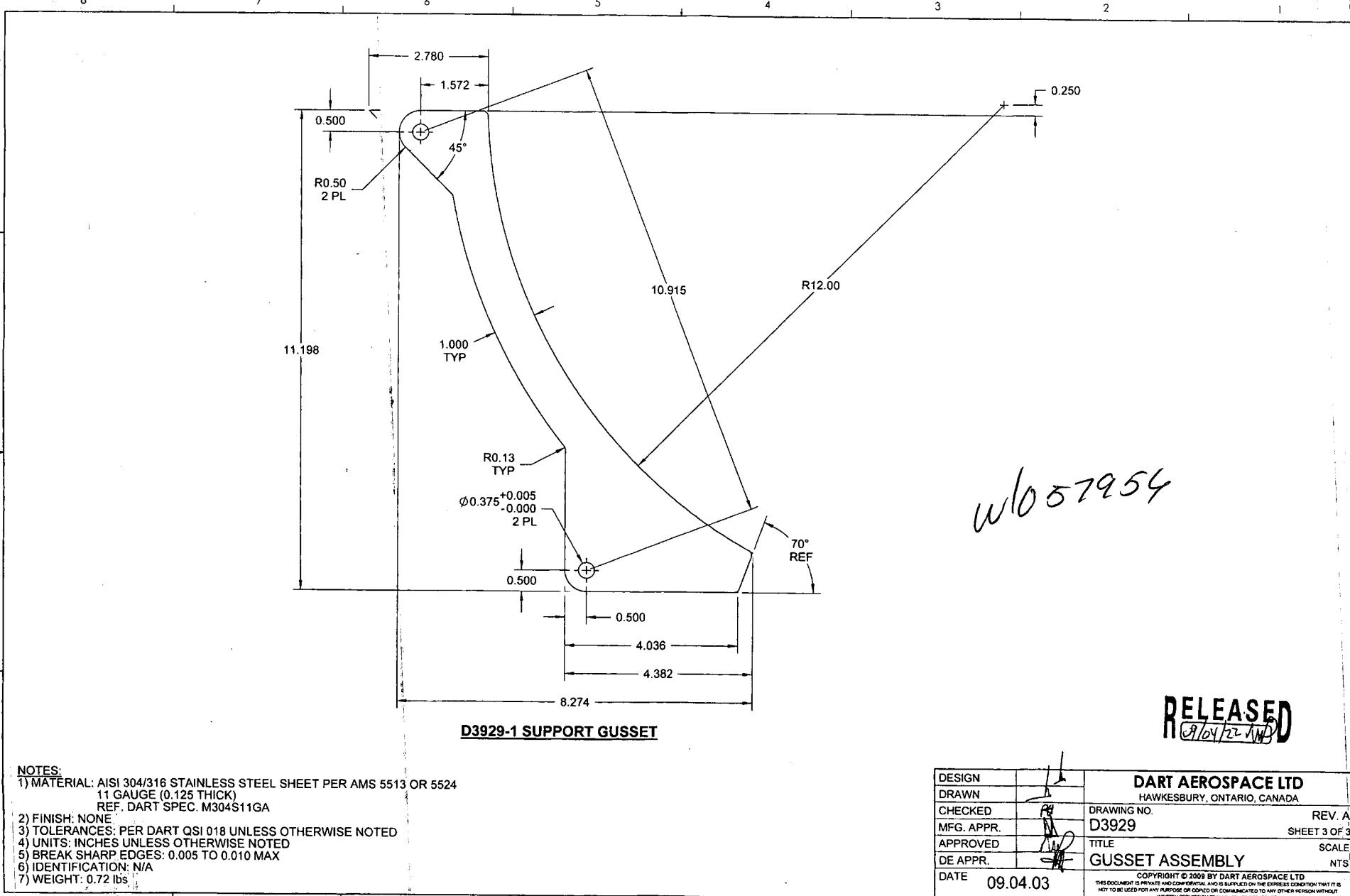
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MFG. APPR.	<i>[Signature]</i>	REV. A
APPROVED	<i>[Signature]</i>	SHEET 3 OF 3
DE APPR.	<i>[Signature]</i>	TITLE GUSSET ASSEMBLY
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